

Work Order ID 71134

Thursday, June 23, 2011 11:07:49 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/06/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch: 117884 0.00



Large Fab

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required

INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

Pl

Pl 11.08.16

De 11.08.10

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11.08.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

S. Moch



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Handwritten signature and date: 12/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
400 OF
8:20

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

IX Ø M-L 11/08/17

M 118439

140

HandFinishing

0.00



HandFinish

Hand Finishing

Memo

0.00

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

M118313

SPRAY PAINT Black M11811a

IX Ø M-L 11/08/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 Packaging Packaging	Identify as per dwg & Stock Location: <i>G-A</i> <i>w/o 71133</i> Memo	0.00 0.00							
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

*1 6 M 2108/12**EF 11/08/18 ①**11/8/18 JF**11-08-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:07:45 AM

Page 1

Work Order ID: 71134

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
IPP Rev:N06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R 10.06.29
added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117

Manufactured

No

100

Each

43.0000

2

2



Clevis

Location

Loc Qty

Loc Code

WA

31

69890

31

WA005

12

55729

12

*** ONLY APPLICABLE ON D130-701-041 -IF
NOT USED, PLEASE MARK N/A ***

D2232-1

Manufactured

No

100

Each

18.0000

2

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

18

70842

18

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Thursday, June 23, 2011 11:07:45 AM

Page 2

Work Order ID: 71134

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2327-1

Manufactured No

100

Each

31.0000

2

2



Spacer Bushing

Location

Loc Qty

Loc Code

WA

20

69728

20

WA005

11

64899

11

D2506

Manufactured No

100

Each

5.0000

1



Label Plate

Location

Loc Qty

Loc Code

WA

5

69262

5

D2581

Manufactured No

100

Each

105.0000

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

105

68964

4

69258

28

69739

22

70766

51

D3166-3

Manufactured No

100

Each

2.0201

1



Basket Hoop

Location

Loc Qty

Loc Code

WA007

2.02010527

64928

0.02010527

68442

2

Thursday, June 23, 2011 11:07:46 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Thursday, June 23, 2011 11:07:46 AM

Page 3

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Parent Item Name: Basket Lid 205/350



Start Date: 6/23/2011

Required Date: 7/13/2011

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F Purchased No

100 sf

479.0034

18

18.94737



Expanded Metal Flat SS



6/11.08.16

Location

Loc Qty

Loc Code

MAT

38.2107

117708

38.2107

WA

440.7927

115012

95

117197

102.9036

117455

16.0341

117896

226.855

~~1118181~~

M118450

M304TS0.750W.065

Purchased

No

100

f

565.5786

43.5804

45.87411



304 SQ Tube .75x.75x.065W



De 11.08.10.

Location

Loc Qty

Loc Code

MAT018

451.7236

117598

374.0249

117636

77.6987

WA007

113.8549906

116267

99.549272

116763

14.3057186

m118181

(45.87411)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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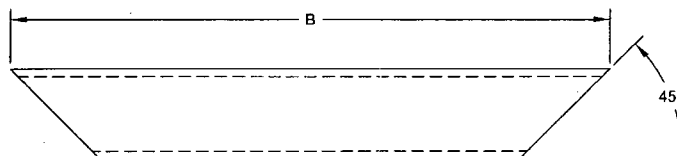
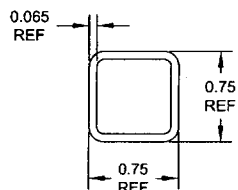
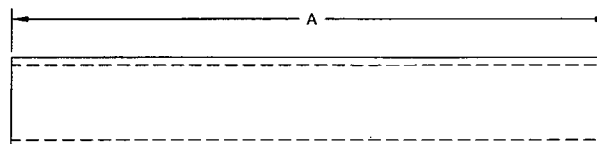
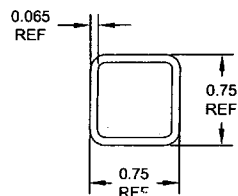
PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71134

CL 11/06/23

RELEASED
08-08-21/11/18

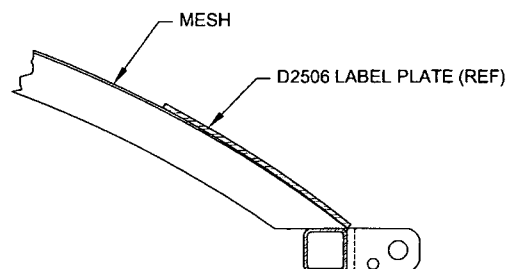


D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



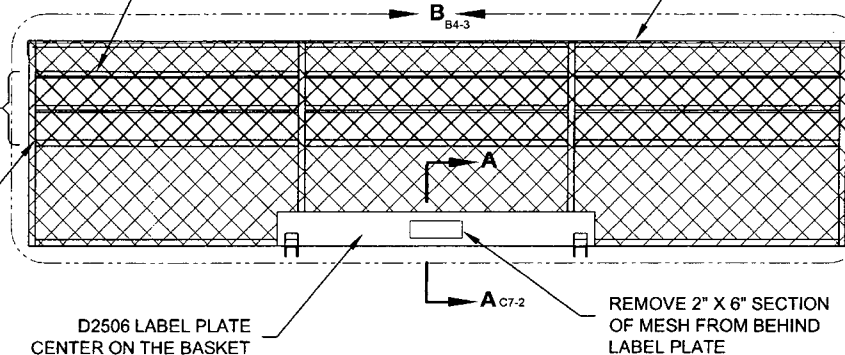
SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



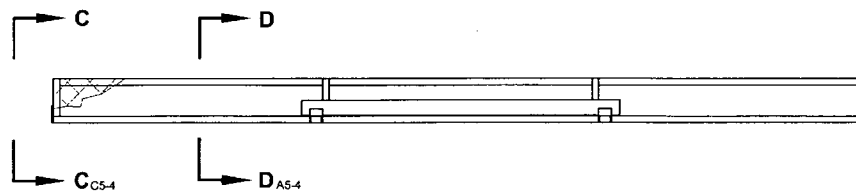
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

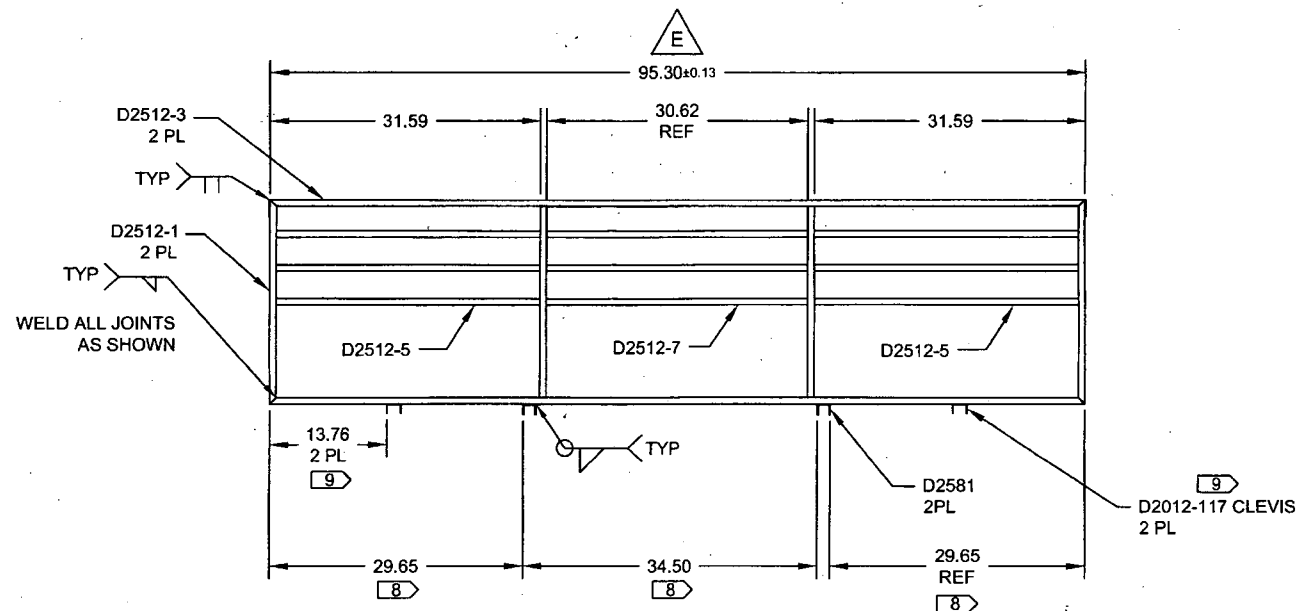
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



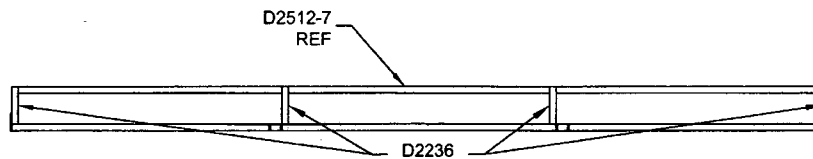
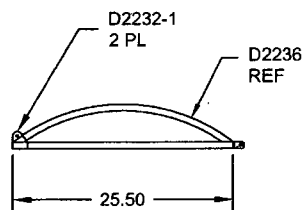
RELEASED
05 05 21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



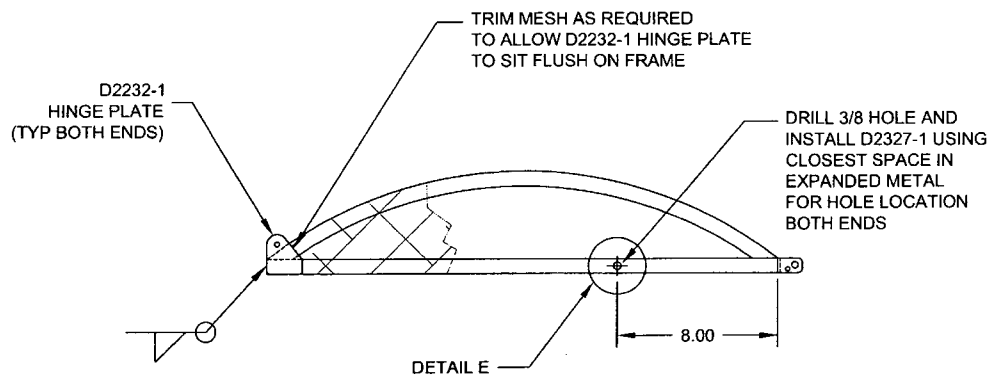
RELEASED
08-06-17

NOTES:

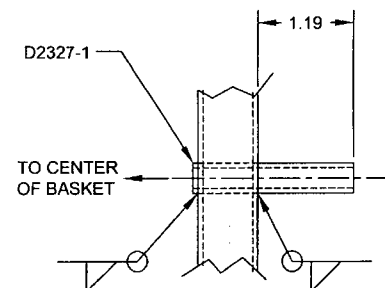
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	10	D2512	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	BASKET LID ASSEMBLY (350/212)	NTS
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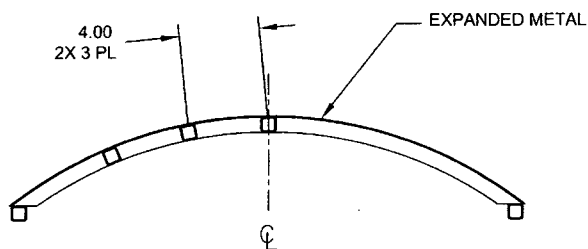
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

